

Work Order ID 109848

Tuesday, December 03, 2013 1:27:46 PM

109848

Page 2

Item ID: D3022-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Seat Pan

Stop

NS2Start Date: 12/3/2013 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/4/2013 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check	0.00 27 9-89				1			
130 *130* Brake NC Brake NC	Memo Bend as per dwg	0.00							13/12/03
140 *140* QC Quality Control	Memo QC5- Inspect part completeness to step on W/O	0.00 27 9-89							13/12/03
		0.00 13/12/04							

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Item ID: D3022-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Seat Pan

Stop

NS2

Start Date: 12/3/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/4/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: W/A CO1

0.00

1 12/13-12-5***200***

Packaging

Packaging

Memo

0.00

210

QC21- Final Inspection - Work Order Release

0.00

13/12/9 AA***210***

QC

Quality Control

Memo

0.00

12/13-12-5

Picklist Print

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Work Order ID: 109848

109848
D3022-1

Parent Item: D3022-1

Parent Item Name: Seat Pan

Start Date: 12/3/2013

Required Date: 12/4/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.01.23Revised NG

IPP Rev:D 08-04-16 now water jet DD verified by:EC

IPP Rev:E 08-12-18 as per ECN08-582 DD verified by:EC

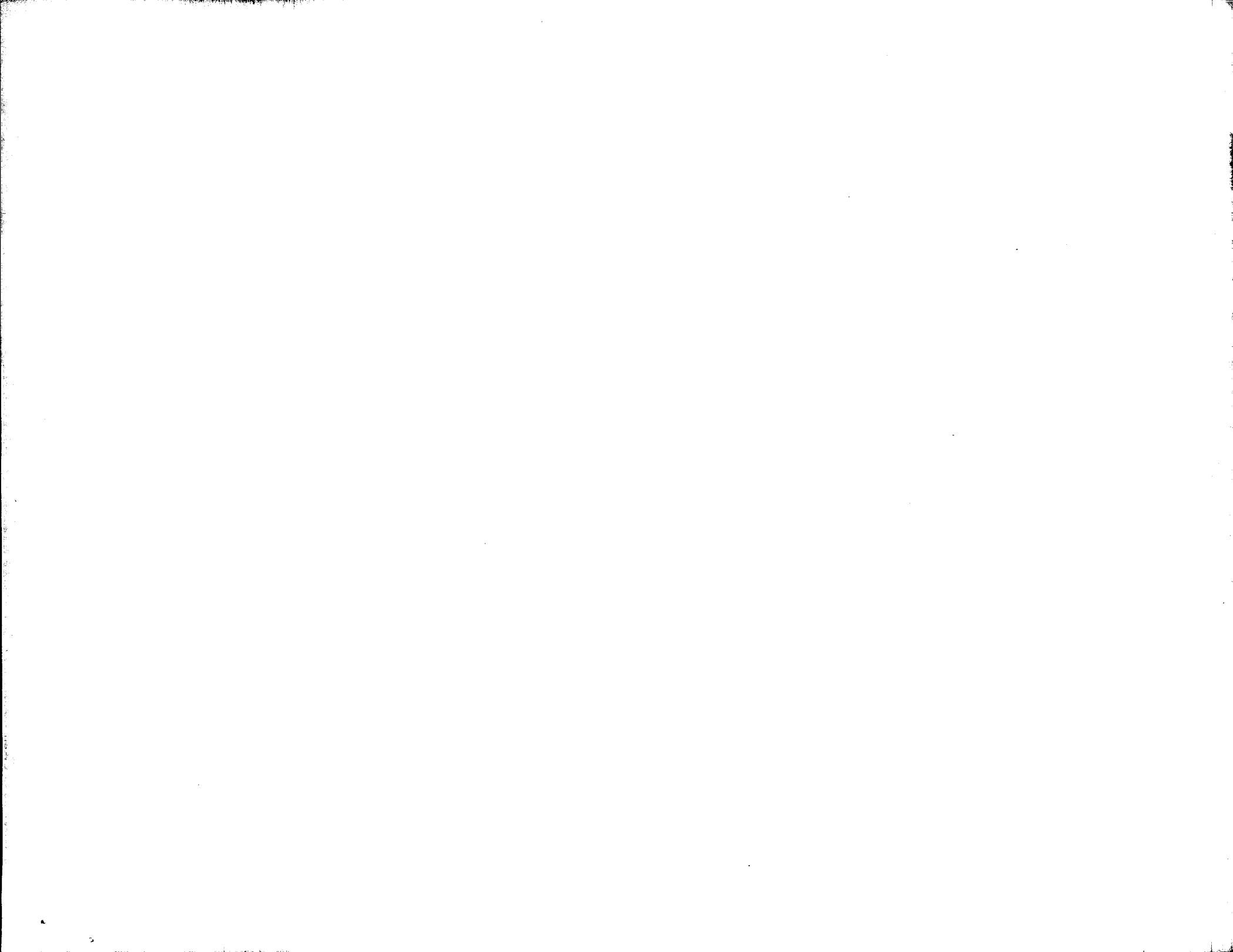
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	411.0000	1.6232	2		**	

M2024T3S 032

2024-T3 .032 sheet

Location	Loc Qty	Loc Code
MAT022	411	
118523	2	
121309	17	
123574	12	
124987	6	
M127668	374	127668

Jm13-12-3



NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

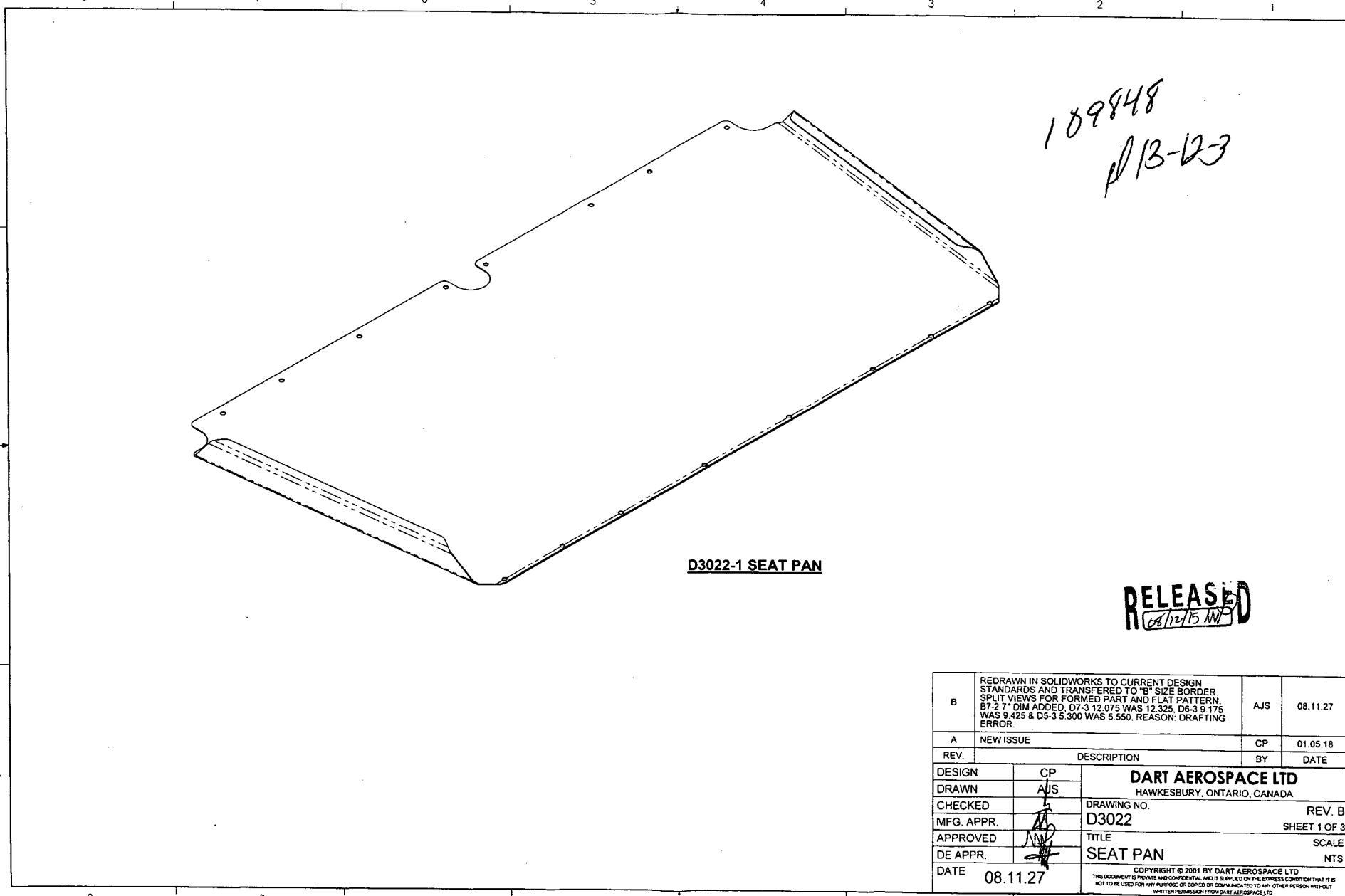
Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>								
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>								
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>								
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
														<input type="checkbox"/> Other	

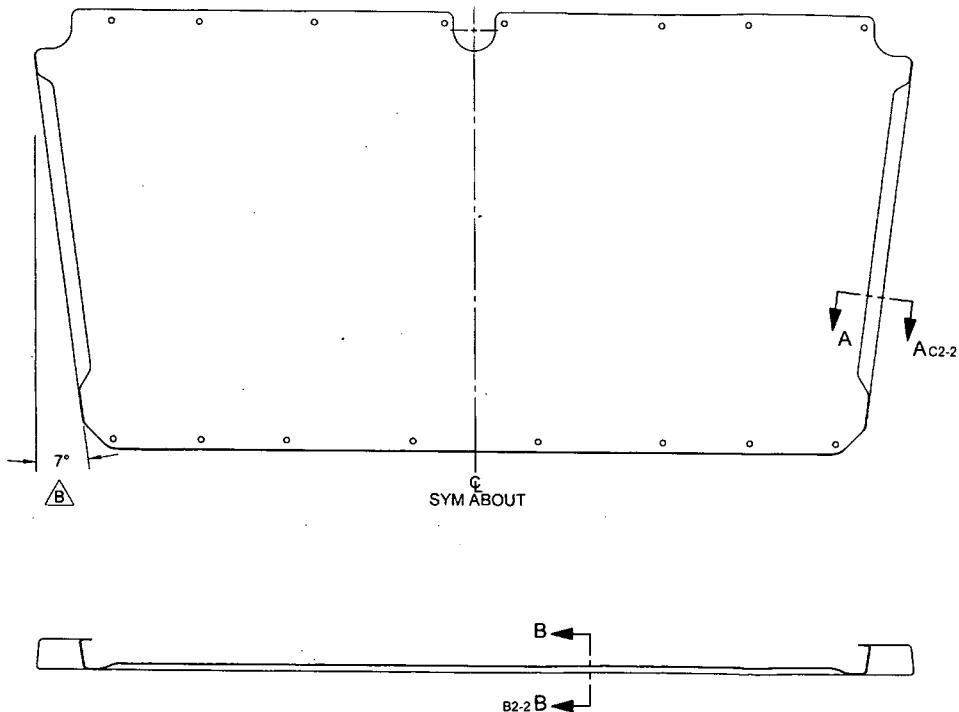
DART AEROSPACE LTD	Work Order:	1098418
Description: Seat Pan	Part Number:	D3022-1
Inspection Dwg: D3022 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	JM	Audited by:	27	Preliminary Approval:	
Date:	13-12-3	Date:	13-12-3	Date:	

Rev	Date	Change	Revised by	Approved
A	08.06.13	New Issue	KJ/DD	
B	11.06.21	Dwg Rev updated	KJ	

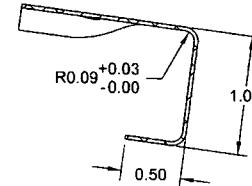




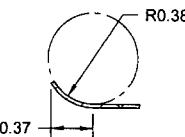
D3022-1 SEAT PAN  B

NOTES:

- 1) MATERIAL: MAKE FROM D3022-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.36 lbs



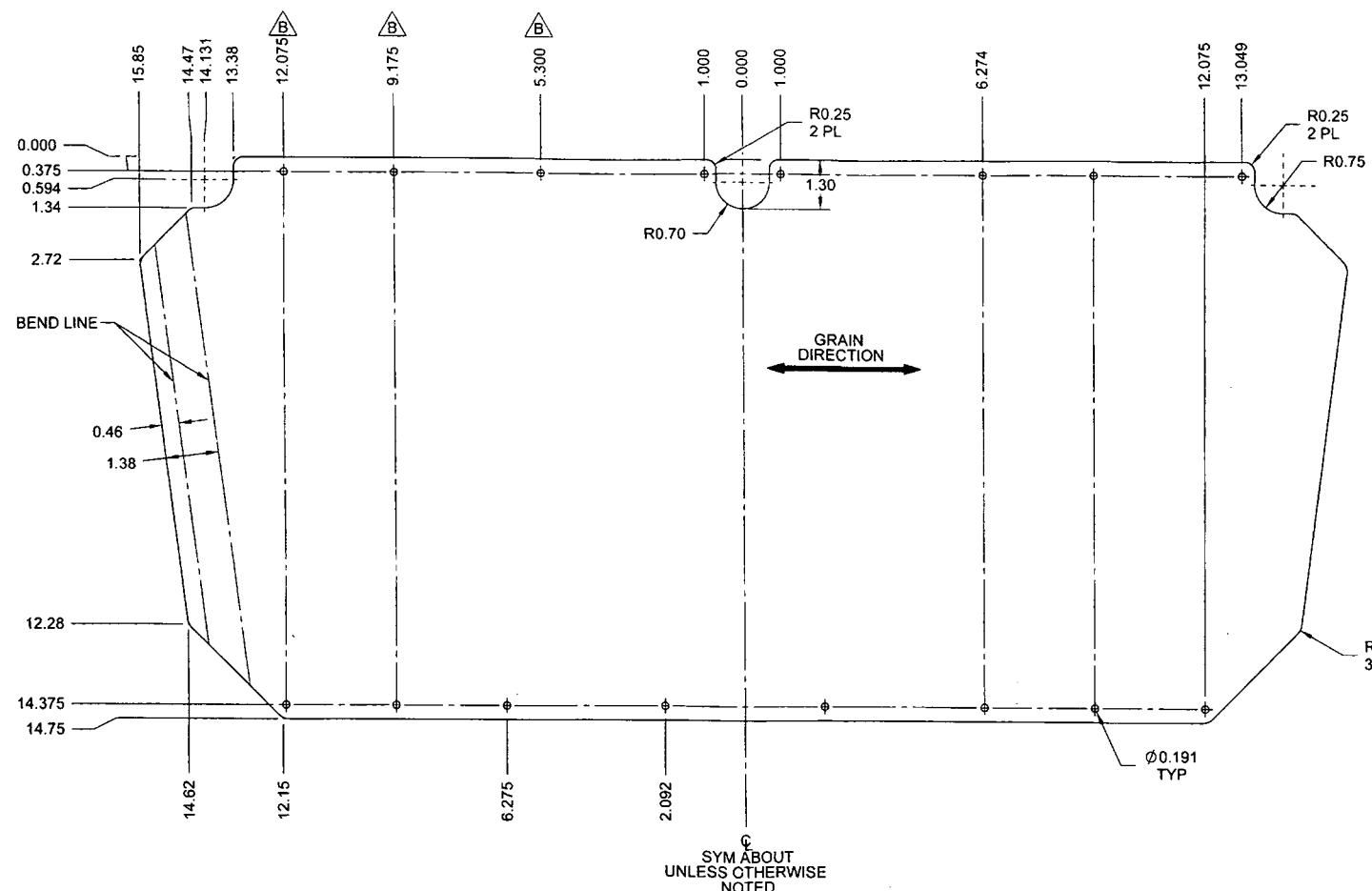
SECTION A-A C4-2
SCALE 4X



SECTION B-B A6-2
SCALE 4X

RELEASED
08/12/15 TAD

DESIGN	CP	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.	AD	D3022	SHEET 2 OF 3	
APPROVED	AM	TITLE	SCALE	
DE APPR.	AT	SEAT PAN	NTS	
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NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN **B**

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. B	
APPROVED		D3022	
DE APPR.		SHEET 3 OF 3	
DATE	08.11.27	SCALE	NTS

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